

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014804**Date Inspected:** 02-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1800**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

7DW

Shield Metal Arc Welding (SMAW) repair was performed on weld joint 022 located at OBW8A counter weight side of segment. Welder is identified as Mr. Zai Dawei (068097). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and WR13212 procedure.

7CW+7DW

Shield Metal Arc Welding (SMAW) repair was performed on weld joint 013 located at EP059-001 counter weight side of segment. Welder is identified as Mr. Lu Xiaolin (067079). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-1G (1F)-FCM-Repair-1 and WR12992 procedure.

Shield Metal Arc Welding (SMAW) repair was performed on weld joint 014 located at EP059-001 counter weight

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side of segment. Welder is identified as Mr. Lu Xiaolin (067079). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-1G (1F)-FCM-Repair-1 and WR12993 procedure.

9AW+9BW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 004 located at OBW9B cross beam side of segment. Welder is identified as Mr. Dong Haitao (067183). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 004 located at OBW9B cross beam side segment. Welder is identified as Mr. Zhang Quanfa (066326). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 005 located at OBW9B cross beam side segment. Welder is identified as Mr. Zhao Aifei (067942). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 001 located at OBW9B bottom plate splice of segment. Welder is identified as Mr. Zhang Quanfa (066038). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

8AW

Flux Core Arc Welding (FCAW) welding was performed on weld joint 023 located at OBW8 counter weight side of segment. Welder is identified as Mr. Wang Bing (048696). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2232-Tc-U4b-F-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 023 located at OBW8 counter weight side of segment. Welder is identified as Mr. Hao Jianxiang (067665). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 023 located at OBW8 counter weight side of segment. Welder is identified as Mr. Zai Dawei (068097). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

Shield Metal Arc Welding (SMAW) repair was performed on weld joint 045 located at SEG043A cross beam side of segment. Welder is identified as Mr. Ni Leijiang (037723). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and CWR1560 procedure.

Y Location of repairs areas by above noted welder (037723) is located at 610 and 790mm.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract

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documents.



### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (150-0042-2372), who represents the Office of Structural Materials for your project.

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**Inspected By:** Alaniz, Joe

Quality Assurance Inspector

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**Reviewed By:** Carreon, Albert

QA Reviewer